



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE105-42121W6-5
Job Sheet 204096



Handwritten: DAS 11/12/19

Part No: RBE105-42121W6-5

Job Qty: 4 pcs

Part Name: Guide Pin



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/3/19

Job Tracking No:

Due Date: 12/30/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE105-42121W6 REV.1 IPP Rev. A 19.10.29 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Bandsaw - 1	4 pcs	12/30/19	12/30/19	0.00	0.20	Bandsaw - 1	<i>BT 19-12-05</i>
110	Outsource - 1 - Heat Treat	4 pcs	12/30/19	12/30/19			-MEI001-VC ATL002	<i>2019-12-06</i>
120	Packaging 2-1 - Receive - B4B	4 pcs	12/30/19	12/30/19	0.00	0.00	Packaging 2 - 1 - B4B	
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	
							Packaging 2 - 4 - B4B	
							Packaging 2 - 6 - B4B	
							Packaging 2 - 7 - B4B	
							Packaging 2 - 8 - B4B	
							Packaging 2 - 9 - B4B	
							Packaging 2 - 10 - B4B	
							Packaging 2 - 11 - B4B	
							Packaging 2 - 12 - B4B	
							Packaging 2 - 13 - B4B	<i>DEC 17 2019</i>
							Packaging 2 - 14 - B4B	
							Packaging 2 - 15 - B4B	
							Packaging 2 - 16 - B4B	
							Packaging 2 - 17 - B4B	
							Packaging 2 - 18 - B4B	
							Packaging 2 - 19 - B4B	
							Packaging 2 - 20 - B4B	
							Packaging 2 - 21 - B4B	
							Packaging 2 - 22 - B4B	
							Packaging 2 - 23 - B4B	
							Packaging 2 - 24 - B4B	
							Packaging 2 - 25 - B4B	
							Packaging 2 - 26 - B4B	
							Packaging 2 - 27 - B4B	
							Packaging 2 - 28 - B4B	
							Packaging 2 - 29 - B4B	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S237395



Part: RBE105-42121W6-5

Job No: 204096

Serial No/Batch: S237395

Revision: 1

Inspector:

Exp Date:

Instructions:

Date: 12/17/19

Plex 12/3/19 7:10 AM Dart.lajeunesse.marie

130 QC 6	4 pcs	12/30/19	0.00 0.00	Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
140 SL-154 - B4B	4 pcs	12/30/19	0.25 0.20	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	DAS
				QC 6 - 40	81
				QC 6 - 81	9-89
				SL-154 - 1 - B4B	
				QC 2 - 1	
150 QC 2	4 pcs	12/30/19	0.00 0.00	QC 2 - 12	
				QC 2 - 14	
				QC 2 - 17	
				QC 2 - 19	
				QC 2 - 2	
				QC 2 - 20	
				QC 2 - 22	
				QC 2 - 23	
				QC 2 - 25	
				QC 2 - 32	
				QC 2 - 33	
				QC 2 - 35	
				QC 2 - 39	
				QC 2 - 4	
				QC 2 - 40	
				QC 2 - 44	
				QC 2 - 45	
				QC 2 - 48	
				QC 2 - 49	
				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
160 QC 8	4 pcs	12/30/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	

				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
200 Packaging 3-1 - Stock - B4B	4 pcs	12/30/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210 QC 21 - SA	4 pcs	12/30/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	

DEC 18 2019

DM

GA 137A

DEC 19 2019

Part Op 100 - 1-Cut bar to 24.0". 2-Prepare for outsource.
Descriptions: 110 - 1-Issue P/O; _____ Heat Treat RC 50-55 2-Bead blast 3-Material type; 4140 4-Apply LPS-3 to ALL steel parts 5-Certificate of Conformity is required
120 - (Pac2-Receive & Inspect for Damage & Mat'l Certs.)
130 - (QC6- All purchased or subcontracted products)
140 - 1-Machine as per folio FD104 FOLIO REV: AA DWG REV: 1 2-Deburr 3-Apply LPS-3 to ALL steel parts

150 - QC2- Inspect parts off machine FAI/FAIB

160 - QC8- Inspect parts - second check

200 - 1-Identify as per dwg & Stock Location:_____ 2-Apply LPS-3 to ALL steel parts.

210 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140QT-R0.750	AISI 4140 Quenched &Tempered Steel Round Bar 0.750" Dia.	4800 ft (-12 ea) <u>2.0 FT.</u>	100-Bandsaw - 1	<u>5216622</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	MT-4140QT-R0.750	0	6	0

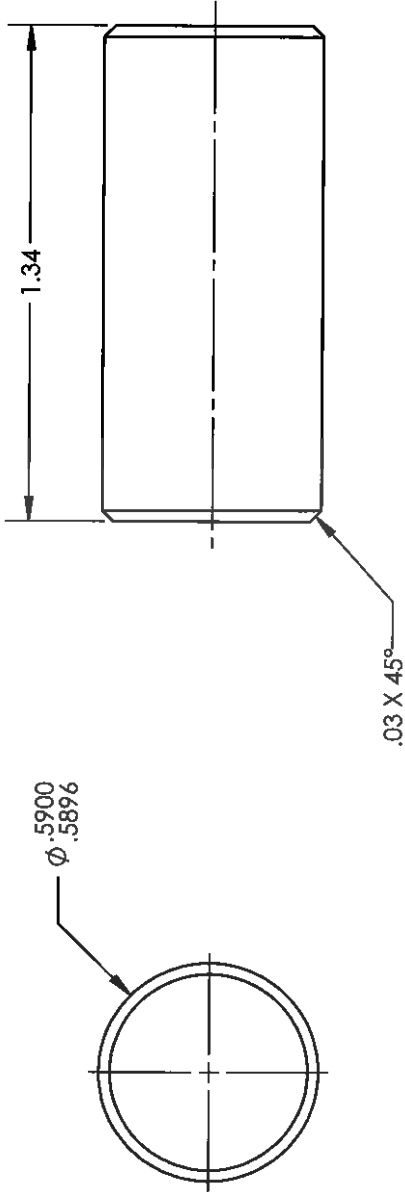
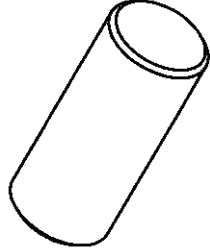
Part Specifications

Specifications could not be found.

Plex 12/3/19 7:10 AM Dart.lajeunesse.marie

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REV		ECR		REVISIONS		DATE		INITIAL		APPROVED	
DESCRIPTION											



SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 203530
ML5
19-1-21



STAKING TOOL

DWG NO.		RBE105-42121W6-5		REV		1	
MAY/AL 4140/4142		UNLESS OTHERWISE SPECIFIED					
HEAT TREAT RC 50-55		DIMENSIONS ARE IN INCHES					
FINISH SEE-1		XXX ± .005 FRACTIONS ± 1/8					
SPEC		.XX ± .01 ANGLES ±.5°					
DRAWN BY: DUERFELDT		.X ± .1 SURFACES ±125/√					
CHECKED: CLOUGH		1. BREAK ALL SHARP EDGES					
OPPS APPR: ANDERSON		.015 x 45° OR .015R					
QA APPR: LINDSAY		2. DIMENSIONAL LIMITS APPLY					
APPROVED: GILBERT		AFTER PLATING					
SCALE 2:1		3. DIMENSIONS AND TOL PER ASME Y14.5-2009					
DATE 1/20/2016		USED ON MODEL					
SHEET 4 OF 4		EC145					

⑤

GUIDE PIN

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .005 FRACTIONS ± 1/16
.XX ± .01 ANGLES ±.5°
.X ± .1 SURFACES = 125/
1. BREAK ALL SHARP EDGES
2. DIMENSIONAL LIMITS APPLY
3. INTERPRET DIM AND TOL PER
ASME Y14.5M-2009

USED ON MODEL

EC145

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only



Job: _____ Part No. _____		DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐					
Date :	Sequence #:	QTY Affected :		MRB (QS1042)					
Description Work Order Deviation		Disposition							
Root Cause ☐ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled Other/Details:				Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Completed By		Lead hand / Supervisor							
QC / QA Coordinator									



Dart Aerospace Ltd.

1270 Aberdeen St

Hawkesbury, ON

K6A 1K7

Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045335



Supplier:

ATL002-VC

Atlantic Heat Treat 2001

401 Frankcom

Ajax

ON

L1S 1R4 Canada

Phone: 866 257 6395

Attention:

Ananth, Nimmy

Ship To:

1270 Aberdeen Street

Hawkesbury

ON

K6A 1K7 Canada

Phone: 613-632-5200

PO No:

POHB045335

PO Date:

12/6/19

Due Date:

12/17/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact:

Guerin, Kimberley

Phone: 613-632-5200 Ext: 298

kguerin@dartaero.com

Pymt Terms:

Net 30

Freight Terms:

Special Comments:

Items												
Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	204096	RBE105-42121W6-5	RBE105-42121W6 1	Guide Pin 1-Issue P/O Heat Treat RC 50-55 2-Bead blast 3-Material type; 4140 4-Apply LPS-3 to ALL steel parts 5-Certificate of Conformity is required	Firmed	-	12/17/19	15 pcs	0 pcs	15 pcs	\$5.8153/pcs	\$87.23
Line Item Note 1 bar = 15 pcs											Grand Total: \$87.23	

Order Notes

Procurement Quality Clauses

A005 right of entry

A012 chemical and physical test report

A016 personnel qualification

A017 raw material identification (as applicable)

A022 Apical Processing

A024 process certifications

A026 certification of material conformance

A041 quality management system

A042 dart notification by supplier

A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

DAS

81

9-89

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit

www.dartaerospace.com for further explanation.

Plex 12/12/19 3:47 PM Dart.Guerin.Kimberley

Shipping Ticket

Sold To: 1448
DART AEROSPACE LTD.
1270 ABERDEEN ST

HAWKESBURY ON K6A 1K7

Page 1 of 1

Ship To: 169643
DART AEROSPACE LTD.
1270 ABERDEEN ST

HAWKESBURY ON K6A 1K7

Purchase Order Number	Packing List No	Customer Job No	Route	Carrier
POHB045335				

Quantity	Part No. / Part Name / Part Description	Pounds
1	PC MATERIAL 4140 BEAD BLAST AND HEAT TREAT TO 50-55RC C OF C, PRT# RBE105-42121W6-5, JOB# 204096	

Container Type	# Of Containers	Cust Cont Id	Container Type	# Of Containers	Cust Cont Id
BOX	1				

NOTICE: OUR LIABILITY IS LIMITED TO OUR INVOICE CHARGES ONLY

Shipped Complete Quantity Shipped: 1
Pounds Shipped: 3.00

RECEIVED

DEC 16 2019

DART AEROSPACE LTD.

52 Rc

12-13-19

Order No.: 172893	Shipped Complete	Quantity Shipped:	1.00
Received By:	Date:	Pounds Shipped:	3.00

Sold To: DART AEROSPACE LTD.

Shipped ON: 12/11/2019

Certification

Date: 12/13/2019

Entry Date: 12/11/2019

Page: 1 of 1

To:
DART AEROSPACE LTD.
1270 ABERDEEN ST

Purchase Order No.: POHB045335

Packing List No.:

HAWKESBURY ON K6A 1K7

Material: 4140

We are pleased to provide you with the following Certificate of Compliance.

Quantity	Part Number / Part Name / Part Description	Pounds
1	1 PC MATERIAL 4140 BEAD BLAST AND HEAT TREAT TO 50-55RC C OF C, PRT# RBE105-42121W6-5, JOB# 204096	3

Insp. Type	Scale	Minimum	Maximum	Number	Other
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Customer Requirements:

Harden rockwell

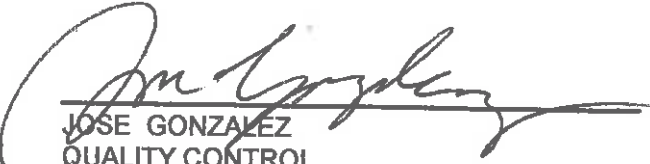
Results:

Harden ROCKWE 50. 55. 52. TESTED AS PER SAMPLING PLAN

HEAT TREATED TO 52 RC AS PER CUSTOMER REQUEST

DAS
81
9-89

STATEMENT OF LIMITED LIABILITY (PLEASE READ CAREFULLY). ALL WORK IS ACCEPTED SUBJECT TO THE FOLLOWING CONDITIONS: It is recognized that even after employing all the scientific methods known to us, hazards still remain in metal treating. THEREFORE, OUR LIABILITY SHALL NOT EXCEED TWICE THE AMOUNT OF OUR CHARGES FOR THE WORK DONE ON ANY MATERIAL (FIRST TO REIMBURSE FOR THE CHARGES AND SECOND TO COMPENSATE IN THE AMOUNT OF THE CHARGES), EXCEPT BY WRITTEN AGREEMENT SIGNED BY THE METAL TREATER. THE CUSTOMER, BY CONTRACTING FOR METAL TREATMENT, AGREES TO ACCEPT THE LIMITS OF LIABILITY AS EXPRESSED IN THIS STATEMENT TO THE EXCLUSION OF ANY AND ALL PROVISIONS AS TO LIABILITY ON THE CUSTOMER'S OWN INVOICES, PURCHASE ORDERS OR OTHER DOCUMENTS. IF THE CUSTOMER DESIRES HIS OWN PROVISIONS AS TO LIABILITY TO REMAIN IN FORCE AND EFFECT, THIS MUST BE AGREED TO IN WRITING, SIGNED BY AN OFFICER OF THE TREATER, IN SUCH EVENT, A DIFFERENT CHARGE FOR OUR SERVICES REFLECTING THE HIGHER RISK TO TREATER, SHALL BE DETERMINED BY THE TREATER AND CUSTOMER. THE TREATER MAKES NO EXPRESS OR IMPLIED WARRANTIES AND SPECIFICALLY DISCLAIMS ANY IMPLIED WARRANTY OF THE FITNESS FOR A PARTICULAR PURPOSE OR MERCHANTABILITY, AS TO THE PERFORMANCE OF CAPABILITIES OF THE MATERIAL AS HEAT TREATED, OR THE HEAT TREATMENT. THE FOREMENTIONED LIMITATION OF LIABILITY STATED ABOVE IS SPECIFICALLY IN LIEU OF ANY EXPRESS OR IMPLIED WARRANTY, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS, AND OF ANY OTHER SUCH OBLIGATION ON THE PART OF THE TREATER. No claim for shortage in weight or count will be entertained unless presented within five (5) working days after receipt of materials by customer. No claim will be allowed for shrinkage, expansion, deformity, or rupture of material in treating or straightening, except by prior written agreement, as above, nor in any case for rupture caused by or occurring during subsequent grinding. Whenever we are given material with detailed instructions as to treatment, our responsibility shall end with the carrying out of those instructions. Failure by a customer to indicate plainly and correctly the kind of material (i.e., proper alloy designation) to be treated, shall cause an extra charge to be made to cover any additional expense incurred as a result thereof, but shall not change the limitation of liability stated above. Customer agrees there will be no liability on the treater in contract for any special, indirect or consequential damages arising whatsoever, including but not limited to personal injury, property damage, loss of profits, loss of production, recall or any other losses, expenses or liabilities allegedly occasioned by the work performed on the part of the treater. It shall be the duty of the customer to inspect the merchandise immediately upon its return, and in any event claims must be reported prior to the time that any further processing, assembling or any other work undertaken. OUR LIABILITY TO OUR CUSTOMERS SHALL CEASE ONCE ANY FURTHER PROCESSING, ASSEMBLING OR ANY OTHER WORK HAS BEEN UNDERTAKEN ON SAID MATERIAL. No agent or representative is authorized to alter the above conditions, except by writing duly signed by an officer of treater.


JOSE GONZALEZ
QUALITY CONTROL
ATLANTIC HEAT TREATING 2001 LTD

